

Date: Monday, 02/02/2009 4:04:01 PM  
 \*User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BASKET LID ASS'Y (A119)
<b>Job Number</b> :	45430A		
<b>Estimate Number</b> :	12445		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3515041
<b>This Issue</b> :	02/02/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3515 REVA
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	45429A	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	01/04/2009
<b>Written By</b> :		<b>Qty:</b>	1
<b>Checked &amp; Approved By</b> :	JUD 09.02.03	<b>Um:</b>	Each
<b>Comment</b> :	EST rev. A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22321	Basket Hinge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B39454

PD 09-08-02

2.0	D31663	Basket Hoop
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: B46304

SAD 09-03-16

3.0	D23271	Spacer Bushing
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B40390

PD 09-03-16

4.0	D2506	Label Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B44275

PD 09-04-02

5.0	D2581	Mounting Bracket
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B45684

PD 09-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 45430A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: *M110969*

*SAD 09-03-16 (P)*

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 (2) as per dwg D3516

2-Cut rib D3515-3 (2) as per dwg D3516

3-Cut rib D3515-5 (6) as per dwg D3516

4-Cut rib D3515-7 (3) as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

*SAD 09-03-16*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

*PD 09-03-16*

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*CP 09-03-30*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S09/03/30 (X)*

11.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: *M110992*

*SAD 09-03-16 (P)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Job Number: 45430A

Part Number: D3515041

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

SAD 09-03-16

SAD 09-03-16

PD 09-04-02

13.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 09-04-02

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09-04-02 (10)

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1ST COAT:

START TIME:

8:10

OVEN TEMPERATURE:

400°

FINISH TIME:

8:40

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

8:50

OVEN TEMPERATURE:

400°

FINISH TIME:

9:20

FR 09/04/08

(1)

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-08 (1)

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg

wing walk:

17/11/08

black spray paint

17/11/08

BR 09-04-08 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 45430A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JP



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-08 (1)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

AP 45430 09/4/14 (1)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14 (1)

Job Completion



11 09-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





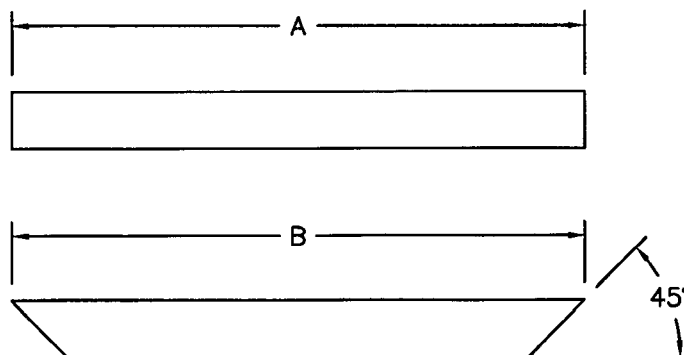
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED

06.11.17 *[Signature]*

**PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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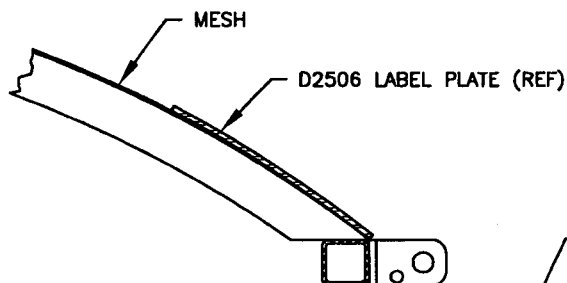
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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
06.05.05	D3515	SHEET 2 OF 4
	TITLE	SCALE
	BASKET LID ASSEMBLY (A119)	1:20

RELEASED

06.11.07



**SECTION A-A**

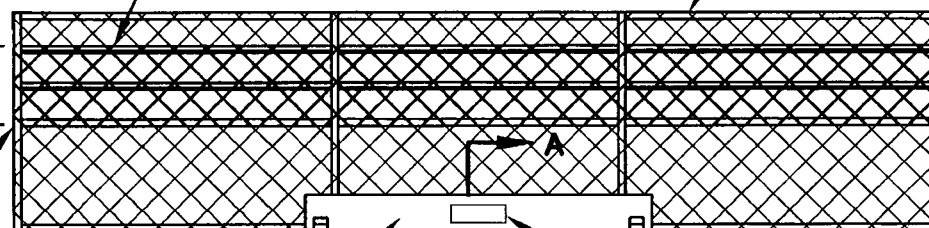
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT

TACK WELD MESH TO  
FRAME AT EVERY AVAILABLE  
LOCATION IN AREA TO BE  
ANTI SKIDDED

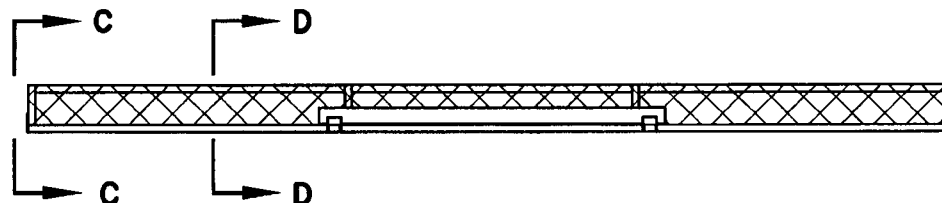
SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY



D2506 LABEL PLATE  
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D3515-041 BASKET LID ASSEMBLY**

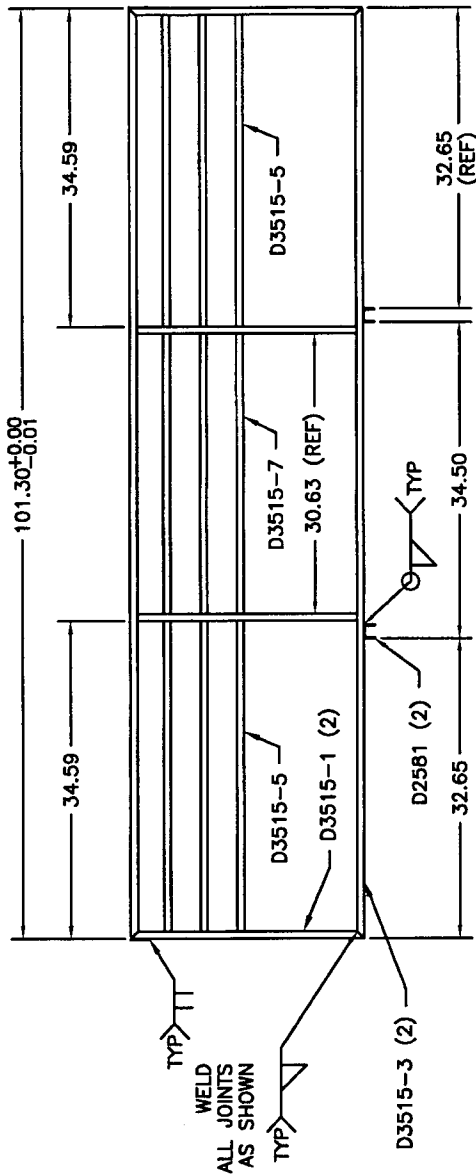
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WHEN REVISED

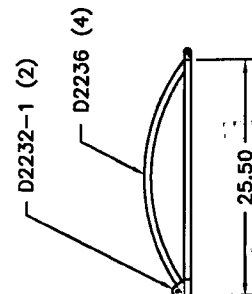
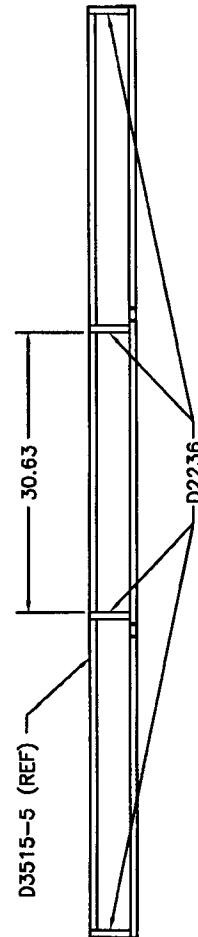
NO. 454304



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 3 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:20



**DETAIL B**  
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



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06.11.17

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RETURN TO

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CONFIDENTIALITY

PROJECT 107

DATE 06.05.05

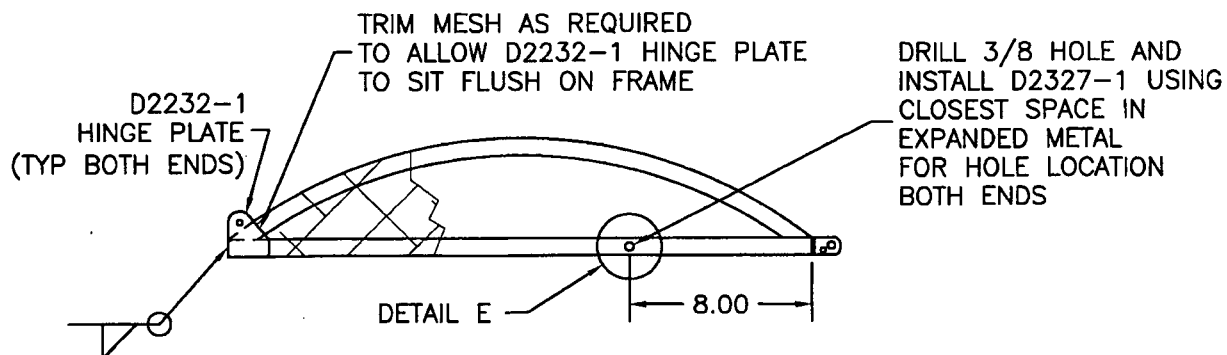
45430A

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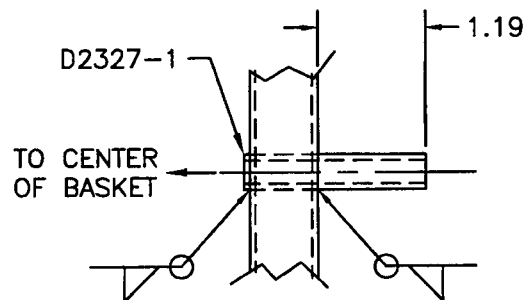
DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8



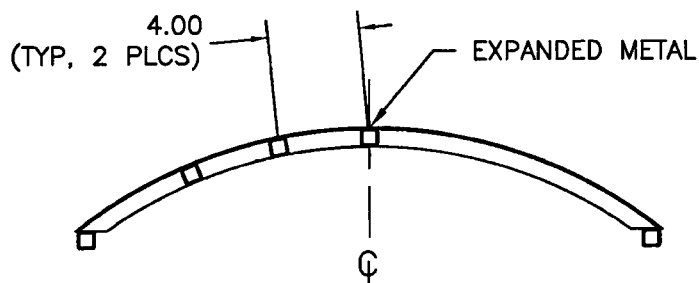
**SECTION C-C SIMILAR BOTH END RIBS**

RELEASED

06-11-17 [Signature]



**DETAIL E**



**SECTION D-D SAME BOTH CENTER RIBS**

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RETURNED  
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WITHDRAWAL  
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